

Work Order ID 128646

Tuesday, January 20, 2015 4:03:03 PM

128646

U/R

Page 1

Item ID: D4812-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Patient Stop Assembly

Stop *NS2*

Start Date: 1/22/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/29/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-01-21 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4812	A U/R <u>OK</u> <u>UP</u> 15/1/21

100	FLOW WATER JET	0.00				10	0		Jm 15-22
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100

Waterjet

FLOW CNC Waterjet

600176 .063"

Memo

1- Cut D4812-1F as per Dwg

Dwg Rev: A

Prog Rev: A

2- DEBURR

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Quality Control

Memo

0.00

10 0 Jm 15-22

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128646

Tuesday, January 20, 2015 4:03:03 PM

128646

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Item ID: D4812-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Patient Stop Assembly
Start Date: 1/22/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/29/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						10	✓	15-3-6	Dec
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160						10			28
QC	Memo	0.00							15-03-06
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170						10	✓	15-3-11	2888
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:05 OVEN TEMPERATURE: 320 FINISH TIME: 2:35								

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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[illegible]

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Transport ☐									
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☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Work Order ID 128646

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128646

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Item ID: D4812-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Patient Stop Assembly
Start Date: 1/22/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/29/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location ST371	0.00							
210									
Packaging	Memo	0.00				16X		DAS 26 9.89	MAR 20 2015
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-20

15-3-20

DQA: _____ Date: _____



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Doc/Data									
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Handling/Pre									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 128646

128646

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 1/22/15

Required Date: 1/29/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No				Each	19.0000		20			
D2690-6									**			DAS 28	MAR 12 2015
Lanyard												9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST009				19		130043			
				127693				19					
D4811-1		Manufactured	No				Each	8.0000		20			
D4811-1									**			DAS 28	
Pin, Quick Release												9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST130				8		B128694X12			
				127262				8		8			
MS21042L3		Purchased	No				Each	2,938.000		20			
MS21042L3									**			DAS 28	
Nut												9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FP001				420					
				M130922				420					
				ST305				2515					
				M130799				11					
				M131264				1504		20			
				M131317				1000					
				ST307				3					
				123900				3					

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FAULT CATEGORY

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Picklist Print

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Work Order ID: 128646

128646

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 1/22/15

Required Date: 1/29/15

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-13

Purchased

No

Each

773.0000

20

MS27039-1-13

Screw

DAS

MAR 12 2015

28

9-99

Location

Loc Qty

Loc Code

GA

133

124326

133

ST273A

300

124326

300

ST285

340

340

125654

Each

1,854.000

60

NAS1149D0332J

Purchased

No

NAS1149D0332.J

Washer

DAS

28

9-99

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

29

m130325

29

ST269

1811

m130325

1811

M6061T6S.063

Purchased

No

M6061T6S 063

6061-T6 .063 Sheet

100

sf

116.9148

2.03

22

Jm15-2-2

Location

Loc Qty

Loc Code

MAT021

116.9148

M128941

18.5

M129845

30.8353

M130096

25

M130745

42.5795

m131383

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

ITEM	QTY -041	P/N	PIP PIN
	X	D4812-041	PATIENT STOP ASSEMBLY
1	2	D2690-6	LANYARD
2	2	D4811-1	QUICK RELEASE PIN
3	1	D4812-1	PATIENT STOP
4	2	MS27039-1-13	SCREW
5	2	MS21042L3	NUT
6	6	NAS1149D0332J	WASHER

D4811-1 PIP PIN

D2690-6
6" LANYARD ASSY

D4812-1 PATIENT STOP

D4812-041 PATIENT STOP ASSY

MS27039-1-13 SCREW
NAS1149D0332J WASHER (X3)
MS21042L3 NUT

UNDER REVIEW

13/03/20
Type: D2690-6 9 2690-6

128.646. MLC
1501-21

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4812-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs

A NEW RELEASE		DB	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	2/	D4812	SHEET 1 OF 2
APPROVED	1/	TITLE	SCALE
DE APPR.		PATIENT STOP	NTS
DATE	13.03.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

